

Work Order ID 147887

Wednesday, June 22, 2016 8:44:38 AM

147887

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Item ID: D3564-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Center

Start Date: 6/14/2016 Start Qty: 18.00

18

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100

0.01

100

FLOW WATER JET

Waterjet

Memo

0.48

FLOW CNC Waterjet

1-Cut as per Dwg D3564

Dwg Rev: DProg Rev: D

2-Deburr if necessary

(24)

DC 16/06/24

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.03

Quality Control

(24)

DC 16/06/24

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Stop ***NS2***

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Start Date: 6/14/2016 Start Qty: 18.00

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18

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									DAS 38
QC	Memo	0.06				(24)			JUN 29 2016
Quality Control									
130		0.01							
130	NC BRAKE								
Brake NC	Memo	0.06							DAS 30 9-89
Brake NC	Deburr if necessary					(24)			JUL 11 2016
	Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155Form Joggle as per Dwg D3564 on brake using Jig DT8157								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.06							DAS 38
Quality Control	Ensure joggle as per dwg					(24)			JUL 11 2016

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Item ID: D3564-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center
Start Date: 6/14/2016 Start Qty: 18.00 ***18*** Cust Item ID:
Required Date: 6/20/2016 Req'd Qty: 18.00 ***18*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.30							
Quality Control									

em 16/07/12
16/07/12

Picklist Print

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Work Order ID: 147887

147887

Parent Item: D3564-5

D3564-5

Parent Item Name: Wearplate Center

Start Date: 6/14/2016

Required Date: 6/20/2016

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	202.7172	1.5	28.42105			

M304S16GA

304/316 Sheet .063

on 16/06/25

Location	Loc Qty	Loc Code
MAT010	124.57	
m134677	6.07	
m134982	118.5	
TPI	78.14716	
m134604	78.14716	

27.9

DART AEROSPACE LTD		Work Order:	147887
Description: Wearshoe		Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

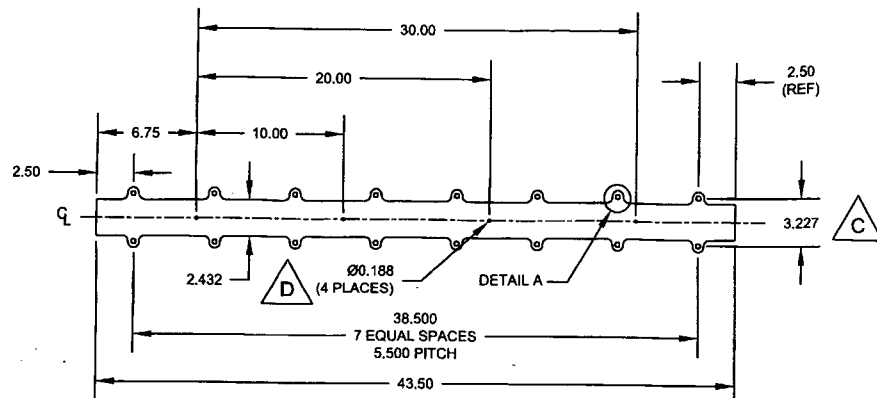
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	/		V: 0.02	
6.75	+/-0.030	6.75	/		Tap	
10.00	+/-0.030	10.00	/			
20.00	+/-0.030	20.00	/			
30.00	+/-0.030	30.00	/			
2.50	+/-0.030	2.50	/			
3.227	+/-0.010	3.227	/			
38.500	+/-0.010	38.500	/			
5.500	+/-0.010	5.497	/			
2.50	+/-0.030	2.50	/			
2.432	+/-0.010	2.437	/			
0.300 x 0.300	+/-0.010	0.301 x 0.301	/			
Ø0.188	+0.005/-0.001	0.189	/			
R0.375	+/-0.010	0.375	/			
0.063	+/-0.010	0.057	/			

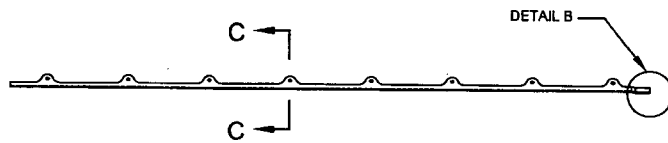
Measured by:	de	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	16/06/24	Date:	JUN 29 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

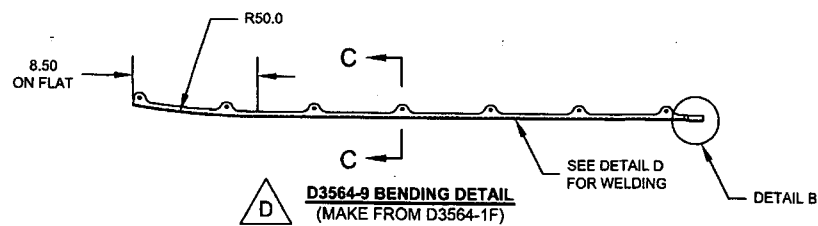
8 7 6 5 4 3 2 1



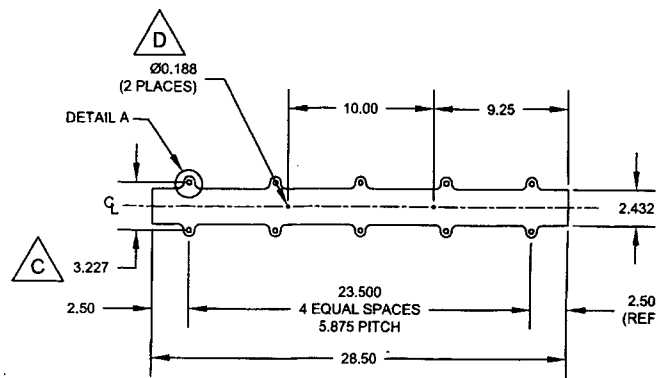
D3564-5F FLAT PATTERN



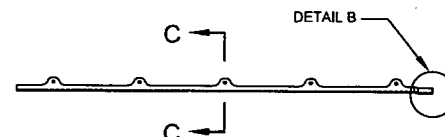
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



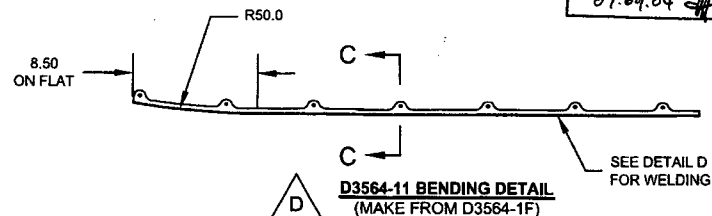
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

STOP
REVIEW
ENGINEER
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ON
NO 147887 M5
1606-17

UNDER REVIEW
OK 07.11.28

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1